

5155718



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order
13260

RBEM632V3008102-10
Job Sheet 190211



Part No: RBEM632V3008102-10

Job Qty: 1 pcs

Part Name: Press



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No:

Due Date: 2/8/19 Feb 20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEM632V3008102 Rev. C IPP Rev. A 18.06.05 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	2/8/19		0.00	0.05	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	2/8/19		0.00	0.00	QC 5 - 10		Miedel Hickel
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	2/8/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

DAS

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9-89

used on job 190207
↓
But we still have the part

					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	1/11
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	1 pcs	2/8/19	0.00 0.00	QC 21 - SA - 21	LAG 21 9-85
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - Small Fab - Assemble as per DWG. See note 9 and 10.

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Loc tite = 648 (M138935)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91801A260	Flat Head Screw	1 Ea (1 ea)	100-Small Fab - 1	5091254
RBEM632V3008102-11	Disc	1 pcs (1 ea)	100-Small Fab - 1	50180317
RBEM632V3008102-12	Bolt Modified	1 pcs (1 ea)	100-Small Fab - 1	5095235

Job Allocations

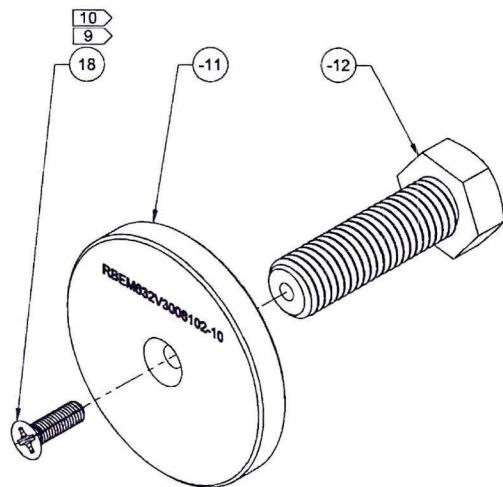
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	91801A260	1	48	0
	RBEM632V3008102-11	1	6	0
	RBEM632V3008102-12	1	6	0

Part Specifications

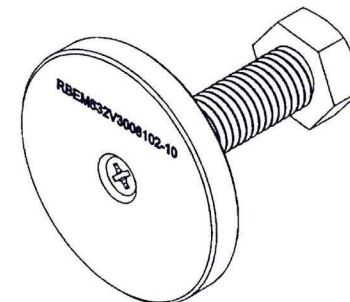
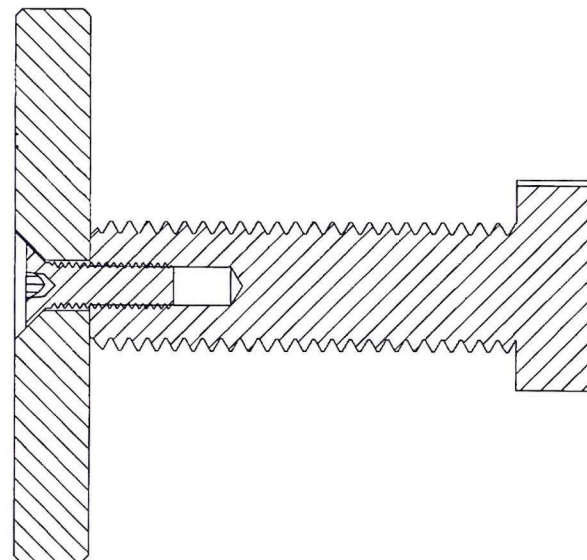
Specifications could not be found.

Plex 2/6/19 8:15 AM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-11	1	RBEM632V3008102-11	DISC
-12	1	RBEM632V3008102-12	BOLT MODIFIED
18	1	McMaster#91801A260 OR EQUIV	SS FLAT HEAD SCREW M5 x 0.8mm x 16mm LG.



RBEM632V3008102-10 PRESS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 190211

115
19-02-06

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"

X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 18 THEN ASSEMBLE WITH ITEM -12 AND REMOVE EXCESS
- 10) INSTALL ITEM 18 UNTIL SCREW IS FULLY SEATED ON ITEM -11

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>W. Lee</i>	TOOL PART #	REV. C
MFG. APPR.	DP	RBEM632V3008102	SHEET 11 OF 13
APPROVED	<i>W. Lee</i>	TITLE	SCALE
DATE	6/6/2018	OUTPUT FLANGE SEAL EXCHANGE	NTS
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Entered: _____ Date: _____



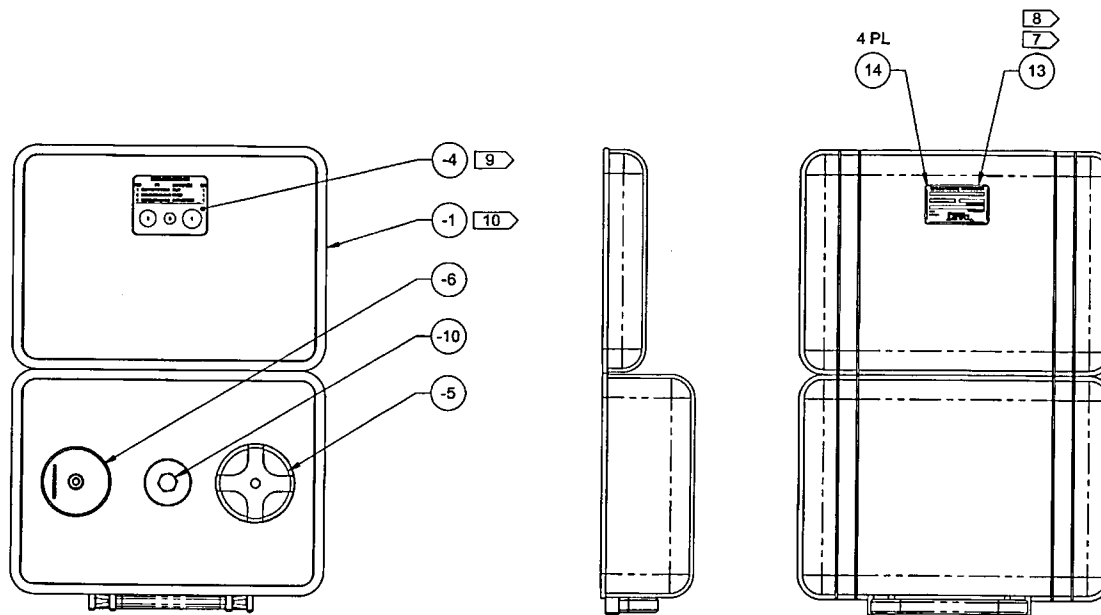
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

ITEM #	QTY	PART #	PART TITLE
-1	1	RBEM632V3008102-1	PACKAGING ASSY
-4	1	RBEM632V3008102-4	POSITION PLACARD
-5	1	RBEM632V3008102-5	BODY
-6	1	RBEM632V3008102-6	SUPPORT RING ASSY
-10	1	RBEM632V3008102-10	PRESS
13	1	RB41011	DART PLACARD
14	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. x 0.425" LG.



RBEM632V3008102 OUTPUT FLANGE SEAL EXCHANGE

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
- 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
- 9) HOT GLUE THE PLASTIC PLACARD ONTO THE TOP FOAM
- 10) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

TEMPLATE UPDATED, PART NUMBERS CHANGED PER DARTS STANDARD, NOTES ADDED, RIVETS ADDED TO SHEET 1, -4 MULTICRAFT PLASTICS #LM922402 MATERIAL ADDED, -5 DIMENSION 3.544 +/- 0.001" CHANGED FOR 3.550/3.555, DIMENSIONED PER DART'S STANDARDS, FINISH ZINC PLATE AND POWDER COAT REMOVED, MATERIAL 4140/4142 CHANGED FOR SS 303/304/316, -6 HARDWARE IN STEEL CHANGED FOR SS, -8 DIMENSION 3.540 +/- 0.001" CHANGED FOR 3.545/3.540, ENGRAVING ADDED, NOTES ADDED, DIMENSION M64 x 1.5 - 6H CHANGED FOR M64 x 1.5 - 6H LEFT HAND, MATERIAL, 4140/4142 CHANGED FOR SS 303/304/316-9 McMaster#1078N13 CHANGED FOR McMaster#98863A368, CENTER DRILL NOTE ADDED		VM
REV.	DESCRIPTION	ECN # BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBEM632V3008102 TITLE OUTPUT FLANGE SEAL EXCHANGE DATE 6/6/2018 SCALE NTS COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.
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MFG. APPR.	DP	
APPROVED	MKen	